Rush

Work Order ID 109632 D2565-101 *109632*

November-22-13 9:50:53 AM B109632

Item ID: D2565-101 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 11/22/13 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 12/06/13 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 13-11-22 **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2565	Rev E

13/11/25

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC	Punch ends and deburr as per dwg NC BRAKE	0.00			DAS 30 9-89	8			
Brake NC	**Memo** Punch as per Dwg D2565 using DT 8313	0.00							
110 *110* Small Fab	Small Fab	0.00				8x		13/11/25	DAS 36 9-89
Small Fab	**Memo** Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	0.00							
120 *120* QC	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89				8			
Quality Control	**Memo**	0.00 13/11/25							

DQA: ____________ Date: ____________

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: ____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	____	
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	____	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	____	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Work Order ID 109632

November-22-13 9:50:53 AM

109632

Item ID: D2565-101 **Accept** *N900040100* **Setup Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Strut

Start Date: 11/22/13 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 12/06/13 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M 126829 **Memo** START TIME: 1:55 OVEN TEMPERATURE: 400 FINISH TIME: 2:25	0.00 0.00				8	ϕ	13-11-26	DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00 DAS 27 9-89 13/11/26				8			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location ST252 **Memo**	0.00 0.00				8x			DAS 26 9-89 13-11-27

DQA: __________ Date: __________

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	____________________	
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	____________________	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	____________________	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Work Order ID 109632

November-22-13 9:50:53 AM

109632

Item ID: D2565-101

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Revision ID:

Item Name: Strut

Start Date: 11/22/13 **Start Qty:** 8.00 *8*

Required Date: 12/06/13 **Req'd Qty:** 8.00 *8*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00					13/11/29		40
QC Quality Control	Memo	0.00							

JMF
13-11-28

DQA: ________ Date: ________

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: ________________

Part No. ________________

NCR No. ________________

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Operator ☐ Offset/Setup ☐ Process ☐ Supplier ☐ Training ☐ Transport ☐ Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other ________________

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

November-22-13 9:50:56 AM

Work Order ID: 109632 *109632*

Parent Item: D2565-101 *D2565-101*

Parent Item Name: Strut

Start Date: 11/22/13 **Required Date:** 12/06/13

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 *M304TR0.750W.049* 304 RD Tube .750 x .049W		Purchased	No			100	f	337.8490	1.71 **	15		DAS 30 9-89	13/11/25

Location	Loc Qty	Loc Code	
MAT017	337.849018		
122312	10.8		
124768	55.31245		
M126183	238.620001		
M126349	33.116567		17

DQA: ____________ Date: ____________

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
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FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
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☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

DART

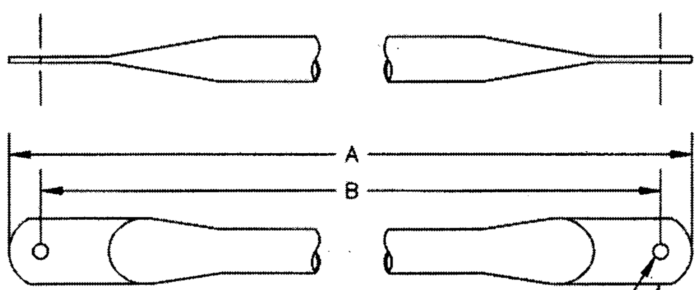
QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2565 REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE 1:3

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

RELEASED 04.05.05

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	–
D2565-109	12.31	11.51	–
D2565-111	13.65	12.85	–
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	–
D2565-209	15.16	14.36	–
D2565-211	14.14	13.34	–
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	–
D2565-309	20.17	19.37	–
D2565-311	16.30	15.50	–
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	–
D2565-409	9.34	8.54	–
D2565-411	13.81	13.01	–



GENERAL NOTES
1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

10962MC5 13-11-22

DART AEROSPACE LTD

Description: Strut		Work Order: 109632
Inspection Drawing: D2565	Rev: E	Part Number: 2565-101

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.52	+/-.030	20.52	✓		✓	SB-11
19.72	+/-.020	19.72	✓		✓	SB-11
Ø.316	+/-.005	Ø.316	✓		✓	SB-11

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
Date 13/11/25	Date 13/11/25	Date 13/11/25	Date